



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

15329

D119-646-041
Job Sheet 193298



Part No: D119-646-041

Job Qty: 1 pcs

Part Name: AW119 Replacement Skidtube with Wearpads - Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/10/19

Job Tracking No: 15329

Due Date: 6/20/19

Created By: Shannon Hadley

Type: SOLD

Description:

Note: DWG IIN-D119-646 REV D, D3887-041 REV E SHEETS 1,2,5,7,8,10,11 IPP RevA: New issue DD verified by:EC IPP rev B 10.02.22 per PAR 09-043 EC verified by:DD IPP REVC 12.11.05 (DEOD3887-B-1)(ecn 12-675) DD verf:JLM IPP REV:D 13.03.20 per chg003 ECN13-534 DD verf:JLM IPP REV:E 17.05.19 as per dwg D3887 rev.e DD verf:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	6/20/19		0.00	0.25	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		mb
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	Handfinish - 1-1 Chemical-B4B	1 pcs	6/20/19		0.00	0.83	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		
							Handfinish - 1 - 6 - B4B		
							Handfinish - 1 - 7 - B4B		
							Handfinish - 1 - 8 - B4B		
							Handfinish - 1 - 9 - B4B		
							Handfinish - 1 - 10 - B4B		D.R.19/09/29
							Handfinish - 1 - 11 - B4B		
							Handfinish - 1 - 12 - B4B		
							Handfinish - 1 - 13 - B4B		
							Handfinish - 1 - 14 - B4B		
							Handfinish - 1 - 15 - B4B		
							Handfinish - 1 - 16 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S176296



Part: D119-646-041

Job No: 193298

Serial No/Batch: S176296

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR02024SE 18/10/17 TC STC LoA P-09-0407-RDIMS

					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
121 QC 7	1 pcs	6/20/19	0.00 0.00		QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	M/G
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
122 QC 5	1 pcs	6/20/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	BE
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
130 Skidtubes - 2 - B4B	1 pcs	6/20/19	0.00 1.54		Skidtubes - 1 - B4B	
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	M/G
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	

135 QC 5	1 pcs	6/20/19	0.00 0.00	Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
140 Skidtubes - 3 - B4B	1 pcs	6/20/19	0.00 1.47	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	mc
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
150 QC 5	1 pcs	6/20/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
160 Skidtubes - 4 - B4B	1 pcs	6/20/19	0.00 1.61	Skidtubes - 1 - B4B	DD
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TF
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
170 QC 5	1 pcs	6/20/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	DAS
				QC 5 - 24	24
				QC 5 - 3	9-89
				QC 5 - 43	

MAY 27 2019

					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
180	QC 10	1	6/20/19	0.00 0.00	QC 10 - 10	DAS
	pcs				QC 10 - 18	24
					QC 10 - 24	9-89
					QC 10 - 43	MAY 27 2019
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
190	Handfinish - 2-1 Pressure- B4B	1	6/20/19	0.00 0.83	Handfinish - 2 - 1 - B4B	
	pcs				Handfinish - 2 - 2 - B4B	MAY 29 2019
					Handfinish - 2 - 3 - B4B	
					Handfinish - 2 - 4 - B4B	
200	Powdercoat - 1 White GI(A)- B4B	1	6/20/19	0.00 0.22	Powdercoat - 1 - B4B	
	pcs				Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	19-5-29
					Powdercoat - 4 - B4B	
210	QC 3	1	6/20/19	0.00 0.00	QC 3 - 10	
	pcs				QC 3 - 13	
					QC 3 - 15	M 19-5-30
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
220	Handfinish - 4-1-Assembly- B4B	1	6/20/19	0.00 3.83	Handfinish - 4 - 1 - B4B	M 19-5-30
	pcs				Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	MAY 29 2019
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	

DAS
15
9-89

240 Handfinish - 4-2-Assembly-B4B	1 pcs	6/20/19	0.00 2.00	Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				Handfinish - 4 - 1 - B4B	2114-3-230
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
245 QC 5	1 pcs	6/20/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS JUN 03 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
255 DC - 1 - B4B	1 pcs	6/20/19	0.00 0.00	DC - 1 - B4B	DAS 21 JUL 08 2019
				DC - 2 - B4B	9-89
260 Packaging 3-1 - Stock - B4B	1 pcs	6/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	Smb 19/7/18
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	

				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
270 QC 21 - FG	1 pcs	6/20/19	0.00 0.00	QC 21 - FG - 21	DAS
				QC 21 - FG - 70	21 JUL 08 2019
				QC 21 - FG - 53	9-85

Part Op 110 - 1- inspect Mat'L D2500-1-190 for damage 2-Cut tube to length as per dwg D3887 (154.8") 3- Ensure squareness of Descriptions: ends and scribe batch#

120 - (Chemical Conversion Coat per QSI005 4.1)

121 - (QC7-Inspect Chemical Conversion Coat)

122 - QC5- Inspect part completeness to step on W/O)

130 - 1- Install drill Jig DT9477 drill X-bolt spacer pilot holes using 3/16" drill first side only. 2- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. 3- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes using DT9477 4- Open crossbolt spacer holes to finished size as per dwg D3887 (section D-D and E-E) ***DO NOT OPEN FWD Saddles Holes*** 5- Deburr, blow out chips from inside of tube. 6- Bond web in place as per Dwg D3887 & QSI 015. A/R Sikaflex: 5163437 - exp: 11-09-12

135 - (QC5- Inspect part completeness to step on W/O)

140 - 1- Bend FWD end of tube using bender 1 and FOLIO 31 bend prog. D3887.***Must use bending aid DT9544, ensure proper positioning*** 2- Cut FWD end of tube as per dwg D3887.***Verify measurement*** 3- Buff out marks left from bending 4- Drill FWD cap holes using DT8215. Open FWD & AFT cap holes to 0.208" 5- Open FWD saddle holes to finished size as per dwg D3887 6- Drill FWD x-bolt spacer holes using DT9816 and open to finished size.(verify measurement) 7- Drill Tow ring hole, using DT10047 locate from FWD saddle hole. (verify measurement). Open to finished size. 8- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg. 9- C'sink FWD cap hole as per detail "C" 10- Drill holes for wearpads using DT8931, open to 0.297". 11- Countersink crossbolt spacer holes, and prepare tube for welding, deburr. 12- Deburr and blow out chips from inside of tube.

150 - (QC5- Inspect part completeness to step on W/O)

160 - NOTE:TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDLING FIXTURE,IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3887. Remember to back drill each hole before welding the other side. Use aluminum rod A/R 2-Grind cross bolt welds flush as per Dwg D3887. Ensure no pin hole, 3-Counterbore 5/16" x 0.750" deep as per Dwg D3887. 4- Deburr & Scribe batch # on Aft end of tube. A/R 139011

170 - (QC5- Inspect part completeness to step on W/O) TEST FIT USING FIXTURE DT10091.

180 - (QC10- Inspect visual per QSI004- ground welds)

190 - Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) ***MASK AREA SHOWN ON SHEET 7, NOTE 9*** START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

210 - (QC3- Inspect Part Finish)

220 - (Assemble as per dwg) 1-Install inserts as per Dwg D3887.

240 - (Assemble as per dwg) 1-Install inserts as per Dwg D3887. 2-Install wearpads, gaskets as per Dwg D3887. Put sikaflex in insert before installing bolts and washers A/R Sikaflex-240/-291 5174342 Sikaflex expire date: 11-12-30

3-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: M138842 4-Inspect for foreign objects as per QSI 024 5-Install D2855-3 Cap and seal with Sikaflex.

Clean excess adhesive. A/R Sikaflex-240/-291 5174342 Sikaflex expire date: 11-12-8 6-Install insert in D2855- Cap. Install cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 5174342 Sikaflex expire date: 11-12-8 7- Wing Walk as per dwg and QSI Batch: 5185187

245 - (QC5- Inspect part completeness to step on W/O)

255 - Photocopy bluefile & type labels per PPP D119-646-041 CHG005

260 - Identify as per dwg & Stock Location: _____)

270 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation
D2500-1-190	Ext'n -1' Beam Tube 4"	1 pcs (1 ea)	110-Skidtubes - 1
D3885-1	Standard Web	1 pcs (1 ea)	130-Skidtubes - 2 - B4B
D2579	Crossbolt Spacer	2 pcs (2 ea)	140-Skidtubes - 3 - B4B
D2855-5	Cap	1 pcs (1 ea)	160-Skidtubes - 4 - B4B
D3681-1	Spacer	12 pcs (12 ea)	160-Skidtubes - 4 - B4B
D3903-1	Spacer	12 pcs (12 ea)	160-Skidtubes - 4 - B4B
ALS4-1032-130	Rivnut	33 Ea (33 ea)	240-Handfinish - 4-2-Assembly-B4B
ALS4-1032-225	Rivnut	1 Ea (1 ea)	240-Handfinish - 4-2-Assembly-B4B
AN3C4A	Bolt	6 Ea (6 ea)	240-Handfinish - 4-2-Assembly-B4B
AN3C5A	Bolt	26 Ea (26 ea)	240-Handfinish - 4-2-Assembly-B4B
D2855-3	Cap	1 pcs (1 ea)	240-Handfinish - 4-2-Assembly-B4B
D3492-5	Plug	24 pcs (24 ea)	240-Handfinish - 4-2-Assembly-B4B
D3672-1	Washer, Phenolic	2 pcs (2 ea)	240-Handfinish - 4-2-Assembly-B4B
D3847-1	Wearpad	5 Ea (5 ea)	240-Handfinish - 4-2-Assembly-B4B
D3847-11	Wearpad	1 Ea (1 ea)	240-Handfinish - 4-2-Assembly-B4B
MS24694-C52	Screw	2 Ea (2 ea)	240-Handfinish - 4-2-Assembly-B4B
NAS1149C0332R	Washer	32 Ea (32 ea)	240-Handfinish - 4-2-Assembly-B4B
NAS1611-005	O-Ring	24 Ea (24 ea)	240-Handfinish - 4-2-Assembly-B4B

010076

Container

S112963
 S14106
 3097840
 5002078
 S145873
 S144950
 5057257
 S167512
 S143675
 S174233
 S126403
 S183338x6
 F164000
 S142046
 S136640
 5067260
 S158078
 S127857

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2500-1-190	1	125	0
130-Skidtubes - 2 - B4B	D3885-1	1	9	0
140-Skidtubes - 3 - B4B	D2579	2	109	0
160-Skidtubes - 4 - B4B	D2855-5	1	51	0
	D3681-1	12	156	0
	D3903-1	12	103	0
240-Handfinish - 4-2-Assembly-B4B	ALS4-1032-130	33	8,859	0
	ALS4-1032-225	1	1,284	0
	AN3C4A	6	1,618	0
	AN3C5A	26	1,310	0
	D2855-3	1	32	0
	D3492-5	24	58	0
	D3672-1	2	1,863	0
	D3847-1	5	52	0
	D3847-11	1	15	0
	MS24694-C52	2	82	0
	NAS1149C0332R	32	4,191	0
	NAS1611-005	24	301	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

15329

D119-646-041 Job Sheet 193246



Part No: D119-646-041

Job Qty: 1 ea

Part Name: AW119 Replacement Skidtube with Wearpads - Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No: 15329

Due Date: 6/20/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: DWG IIN-D119-646 REV D, D3887-041 REV E SHEETS 1,2,5,7,8,10,11 IPP RevA: New issue DD verified by:EC IPP rev B 10.02.22 per PAR 09-043 EC verified by:DD IPP REVC 12.11.05 (DEOD3887-B-1)(ecn 12-675) DD verf:JLM IPP REV:D 13.03.20 per chg003 ECN13-534 DD verf:JLM IPP REV:E 17.05.19 as per dwg D3887 rev.e DD verf:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		6/20/19	0.00	0.00	Start Up Skidtubes-1		
110	Skidtubes	1 pcs		6/20/19	0.00	0.25	Skidtubes-1		
120	HandFinish	1 pcs		6/20/19	0.00	0.83	HandFinish1		
121	QC	1 pcs		6/20/19	0.00	0.00	QC7-1		
122	QC	1 pcs		6/20/19	0.00	0.00	QC5		
130	Skidtubes	1 pcs		6/20/19	0.00	1.54	Skidtubes-1		
135	QC	1 pcs		6/20/19	0.00	0.00	QC5		
140	Skidtubes	1 pcs		6/20/19	0.00	1.47	Skidtubes-1		
150	QC	1 pcs		6/20/19	0.00	0.00	QC5		
160	Skidtubes	1 pcs		6/20/19	0.00	1.61	Skidtubes-1		
170	QC	1 pcs		6/20/19	0.00	0.00	QC5		
180	QC	1 pcs		6/20/19	0.00	0.00	QC10		
190	HandFinish	1 pcs		6/20/19	0.00	0.83	HandFinish2		
200	Powdercoat	1 pcs		6/20/19	0.00	0.22	Powdercoat1		
210	QC	1 pcs		6/20/19	0.00	0.00	QC3		
220	HandFinish	1 pcs		6/20/19	0.00	3.83	HandFinish4		
240	HandFinish	1 pcs		6/20/19	0.00	2.00	HandFinish4		
245	QC	1 pcs		6/20/19	0.00	0.00	QC5		
255	DC	1 pcs		6/20/19	0.00	0.00	DC		
260	Packaging	1 pcs		6/20/19	0.00	0.00	Packaging3-1		
270	QC21-FG	1 Ea		6/20/19	0.00	0.00	QC21		

Part Op 110 - 1- inspect Mat'L D2500-1-190 for damage 2-Cut tube to length as per dwg D3887 (154.8") 3- Ensure squareness of Descriptions: ends and scribe batch#

130 - 1- Install drill Jig DT9477 drill X-bolt spacer pilot holes using 3/16" drill first side only. 2- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. 3- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes usin DT9477 4- Open crossbolt spacer holes to finished size as per dwg D3887 (section D-D and E-E) ***DO NOT OPEN FWD Saddles Holes*** 5- Deburr, blow out chips from inside of tube. 6- Bond web in place as per Dwg D3887 & QSI 015. A/R

140 - 1- Bend FWD end of tube using bender 1 and FOLIO 31 bend prog. D3887.***Must use bending aid DT9544, ensure proper positioning*** 2- Cut FWD end of tube as per dwg D3887.***Verify measurment*** 3- Buff out marks left from bending 4- Drill FWD cap holes using DT8215. Open FWD & AFT cap holes to 0.208" 5- Open FWD saddle holes to finished size as per dwg D3887 6- Drill FWD x-bolt spacer holes using DT9816 and open to finished size.(verify measurement) 7- Drill Tow ring hole, using DT10047 locate from FWD saddle hole. (verify measurement). Open to finished size. 8- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg. 9- C'sink FWD cap hole as per detail "C" 10- Drill holes for wearpads using DT8931, open to 0.297". 11- Countersink crossbolt spacer holes, and prepare tube for welding, deburr. 12- Deburr and blow out chips from inside of tube.

160 - NOTE:TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDELING FIXTURE,IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3887. Remember to back drill each hole before welding the other side. Use aluminum rod A/R 2-Grind cross bolt welds flush as per Dwg D3887. Ensure no pin hole. 3-Counterbore 5/16" x 0.750" deep as per Dwg D3887. 4- Deburr & Scribe batch # on Aft end of tube.

170 - TEST FIT USING FIXTURE DT10091.

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - ***MASK AREA SHOWN ON SHEET 7, NOTE 9*** START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

220 - 1-Install inserts as per Dwg D3887.

240 - 1-Install inserts as per Dwg D3887. 2-Install wearpads, gaskets as per Dwg D3887. Put sikaflex in insert before installing bolts and washers A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____ 3-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: _____ 4 -Inspect for foreign objects as per QSI 024 5 -Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____ 6 -Install insert in D2855- Cap. Install cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____ 7- Wing Walk as per dwg and QSI Batch: _____

255 - Photocopy bluefile & type labels per PPP D119-646-041 CHG005

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n -1' Beam Tube 4"	1 pcs (1 ea)	90-Start up Operation	
D3885-1	Standard Web	1 pcs (1 ea)	130-Skidtubes	
D2579	Crossbolt Spacer	2 pcs (2 ea)	140-Skidtubes	
D2855-5	Cap	1 pcs (1 ea)	160-Skidtubes	
D3681-1	Spacer	12 pcs (12 ea)	160-Skidtubes	
D3903-1	Spacer	12 pcs (12 ea)	160-Skidtubes	
ALS4-1032-130	Rivnut	33 Ea (33 ea)	240-HandFinish	
ALS4-1032-225	Rivnut	1 Ea (1 ea)	240-HandFinish	
AN3C4A	Bolt	6 Ea (6 ea)	240-HandFinish	
AN3C5A	Bolt	26 Ea (26 ea)	240-HandFinish	
D2855-3	Cap	1 pcs (1 ea)	240-HandFinish	
D3492-5	Plug	24 pcs (24 ea)	240-HandFinish	
D3672-1	Washer, Phenolic	2 pcs (2 ea)	240-HandFinish	
D3847-1	Wearpad	5 Ea (5 ea)	240-HandFinish	
D3847-11	Wearpad	1 Ea (1 ea)	240-HandFinish	
MS24694-C52	Screw	2 Ea (2 ea)	240-HandFinish	
NAS1149C0332R	Washer	32 Ea (32 ea)	240-HandFinish	
NAS1611-005	O-Ring	24 Ea (24 ea)	240-HandFinish	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-1-190	1	125	0
130-Skidtubes	D3885-1	1	9	0
140-Skidtubes	D2579	2	109	0
160-Skidtubes	D2855-5	1	51	0
	D3681-1	12	156	0
	D3903-1	12	103	0
240-HandFinish	ALS4-1032-130	33	8,859	0
	ALS4-1032-225	1	1,284	0
	AN3C4A	6	1,618	0
	AN3C5A	26	1,310	0
	D2855-3	1	32	0
	D3492-5	24	58	0
	D3672-1	2	1,863	0
	D3847-1	5	52	0
	D3847-11	1	15	0
	MS24694-C52	2	82	0
	NAS1149C0332R	32	4,191	0
	NAS1611-005	24	301	0

Part Specifications

Specifications could not be found.